

Date: Wednesday, 12/13/2006 2:48:31 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: BRACKET ASSEMBLY		
Job Number	: 29944						
Estimate Number	: 10420						
P.O. Number	: N/A			Part Number	: D3303043		
This Issue	: 12/13/2006 S.O. No. : N/A			Drawing Number	: D3303 REV. B		
Prsht Rev.	: NC			Project Number	: N/A		
First Issue	: N/A			Drawing Revision	: B		
Previous Run	: 28113			Material	: N/A		
Written By	:			Due Date	: 1/15/2007		
Checked & Approved By	:			Qty:	7		
Comment	: Est: A 04.09.07 New Issue KJ/JLM			Um:	Each		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	D33031	Plate		
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)		
		PLATE		
		Pick:		
		Qty Part Number	Description	Batch
		1 D3303-1	Plate	<u>B29951 X7</u>
				<u>B29200 X</u>
2.0	D33033	Bracket		
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)		
		BRACKET		
		Pick:		
		Qty Part Number	Description	Batch
		1 D3303-3	Bracket	<u>B28126 X4</u> <u>B21624 B X1</u>
				<u>B29200 X2</u>
3.0	MS20426AD33	Rivet		
		Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)		
		RIVET		
		Pick:		
		Qty Part Number	Description	Batch
		8 MS20426AD3-3	Rivet	<u>M7681 X 56</u>
4.0	MS20470AD44	Rivet, Universal Head		
		Comment: Qty.: 16.0000 Each(s)/Unit Total : 64.0000 Each(s) (128)		
		Rivet, Universal Head		
		Pick:		
		Qty Part Number	Description	Batch
				<u>M103044</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/02/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/13/2006 2:48:31 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: BRACKET ASSEMBLY	
Job Number: 29944		Part Number: D3303043	
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
16	MS20470AD4-4	Rivet	
5.0	MS21075L3	Nutplate 	
<p>Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s) Nutplate Pick: Qty Part Number Description Batch 4 MS21075L3 Nut Plate m 18534 x28</p> <p><i>ml07/02/06</i></p>			
6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 	
<p>Comment: SMALL & MEDIUM FAB RESOURCE 1 1- Assemble as per Dwg D3303 2- Identify as D3303-043</p> <p><i>ml07/02/06 x7</i></p>			
7.0	QC5	INSPECT WORK TO CURRENT STEP 	
<p>Comment: INSPECT WORK TO CURRENT STEP</p> <p><i>SB 07/02/06 7</i></p>			
8.0	POWDER COATING	POWDER COATING 	
<p>Comment: POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 ****MASK THREADS PRIOR TO PAINT****</p> <p><i>M101601</i></p> <p><i>7x</i></p> <p><i>Mh/gl 07/02/06</i></p>			
9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 	
<p>Comment: INSPECT POWDER COAT</p> <p><i>CC 1/2/08 6</i></p>			
10.0	PACKAGING 1	PACKAGING RESOURCE #1 	
<p>Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____</p> <p><i>CC 1/2/08 7</i></p>			
11.0	QC21	FINAL INSPECTION/W/O RELEASE 	
<p>Comment: FINAL INSPECTION/W/O RELEASE</p> <p><i>CC 07/02/08 7</i></p>			
Job Completion 		<i>6/7/02.28</i>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

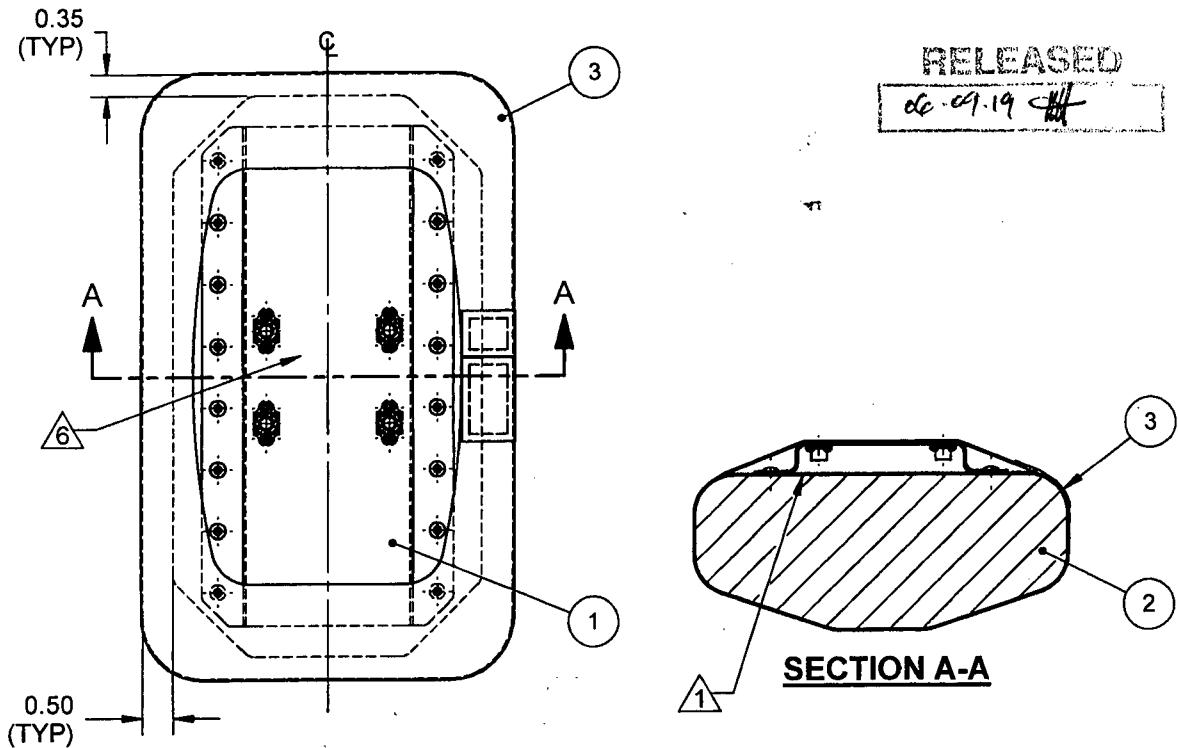
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>PF</i>	DRAWN BY <i>AB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>HF</i>	DRAWING NO. D3303		
DATE 06.08.17	TITLE HEAD REST		SCALE 1:3	
REV A	DATE 04.08.18	DESCRIPTION NEW ISSUE		
B	06.08.17	UPDATED FLAT PATTERN TO FORM PART IN ONE OPERATION USING OFFSET DIE		



D3303-041 HEAD REST

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3303-041	HEAD REST
1	1	D3303-043	BRACKET ASSEMBLY
2	1	D3305-1	FOAM
3	1	D3306-041	COVER ASSEMBLY

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WORK ORDER
NO. *29944*

NOTES:

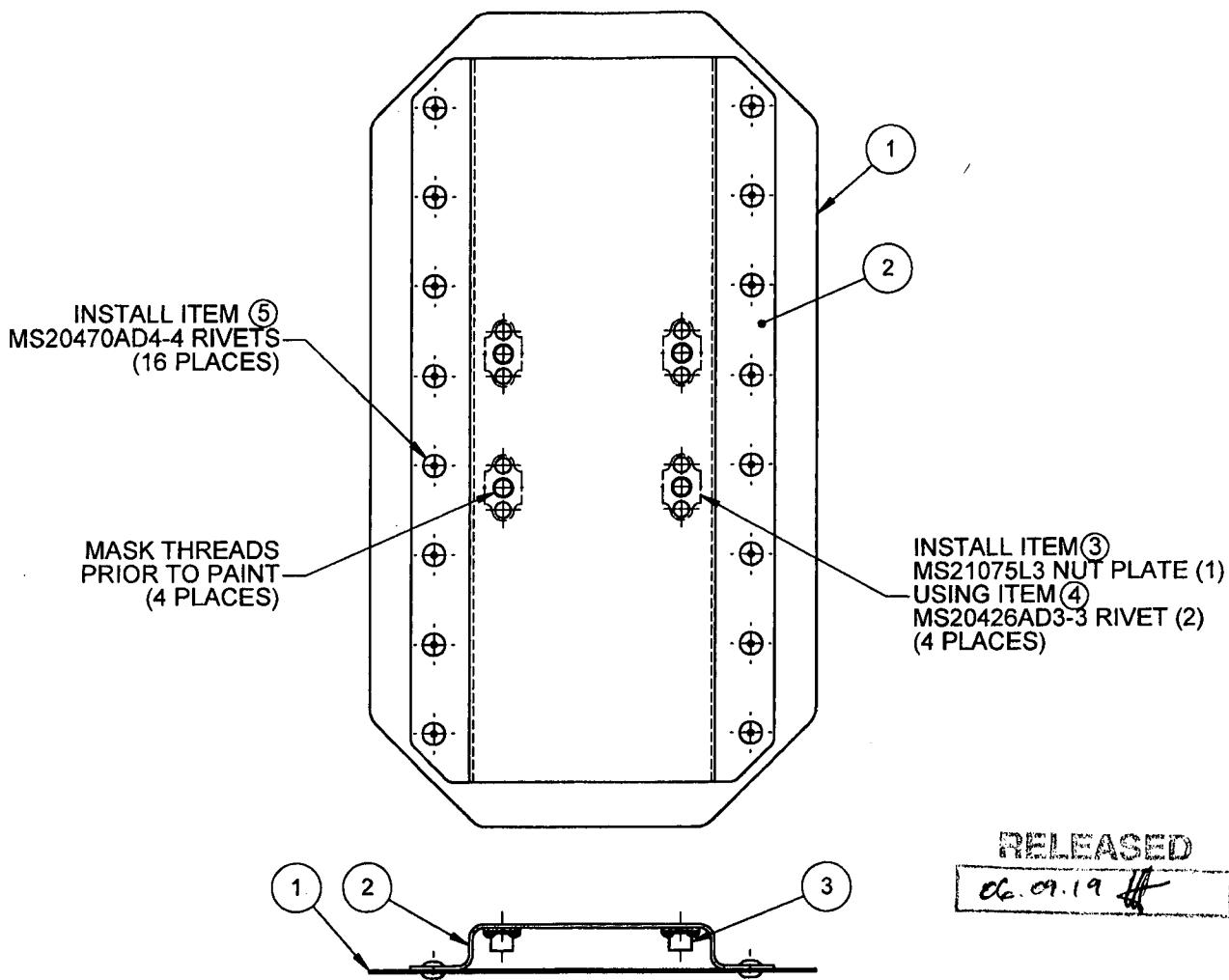
- 1) BOND D3305-1 FOAM TO D3303-043 BRACKET ASSEMBLY USING 3M 1300 ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 2) COVER HEAD REST WITH D3306-041 COVER ASSEMBLY AS SHOWN
- 3) PART IS SYMMETRICAL AT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFY AS FOLLOWS USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD, P/N D3303-041 B/N BXXXXX, FOR PRODUCT
ELIGIBILITY SEE PDA04-11"

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DART

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CHECKED <i>PH</i>	APPROVED <i>CH</i>	DRAWING NO. D3303	REV. B SHEET 2 OF 4
DATE 06.08.17	TITLE HEAD REST	SCALE 1:2	

**D3303-043 BRACKET ASSEMBLY**

ITEM	QTY -043	P/N	DESCRIPTION
	X	D3303-043	BRACKET ASSEMBLY
1	1	D3303-1	PLATE
2	1	D3303-3	HEAD REST
3	4	MS21075L3	NUT PLATE
4	8	MS20426AD3-3	RIVET
5	16	MS20470AD4-4	RIVET

NOTES:

- 1) FINISH: POWDER COAT ASSEMBLY GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

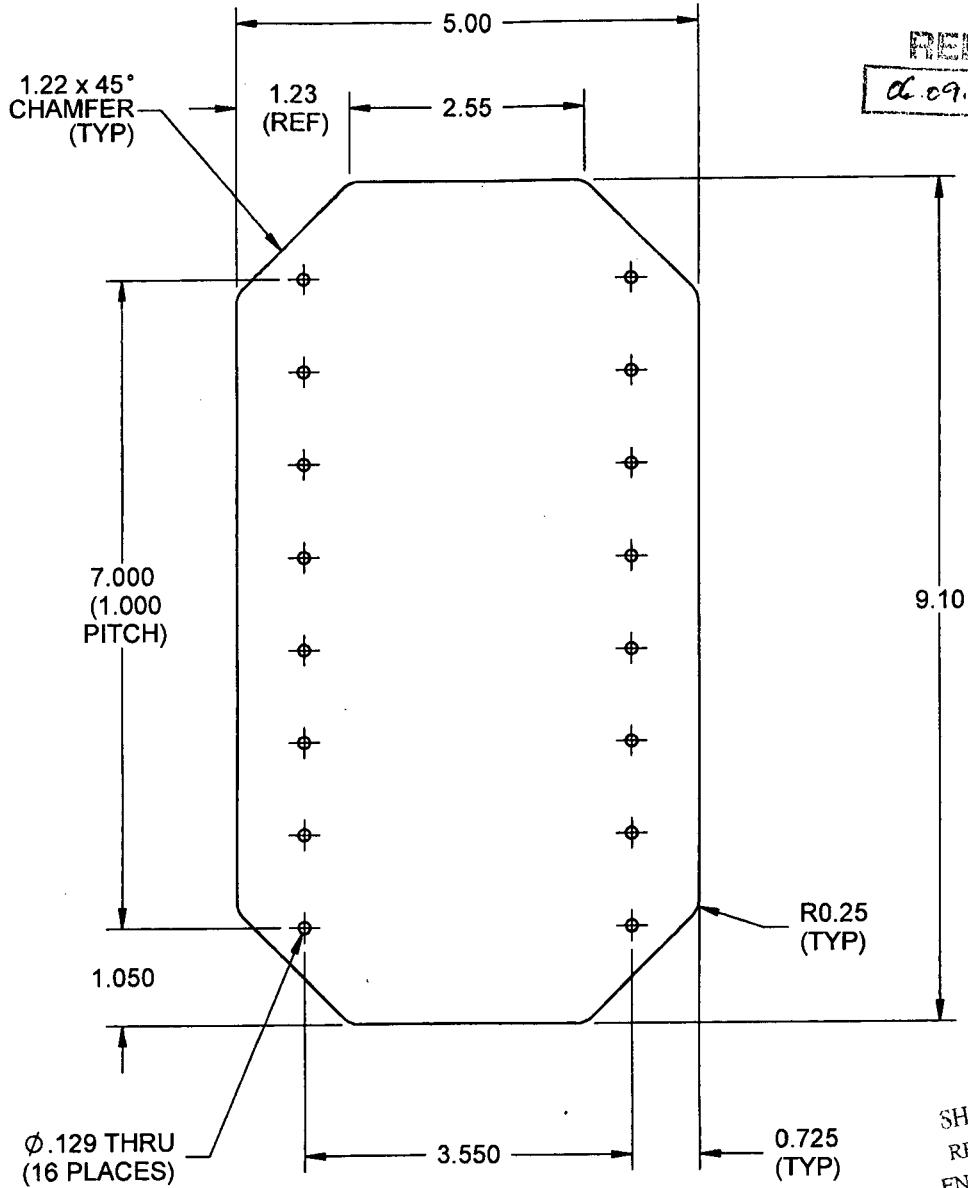
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CHECKED <i>PH</i>	APPROVED <i>SH</i>	DRAWING NO. D3303	REV. B SHEET 3 OF 4
DATE 06.08.17	TITLE HEAD REST	SCALE 1:2	

**D3303-1 PLATE****NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK SHEET
(REF. DART SPEC. M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005.4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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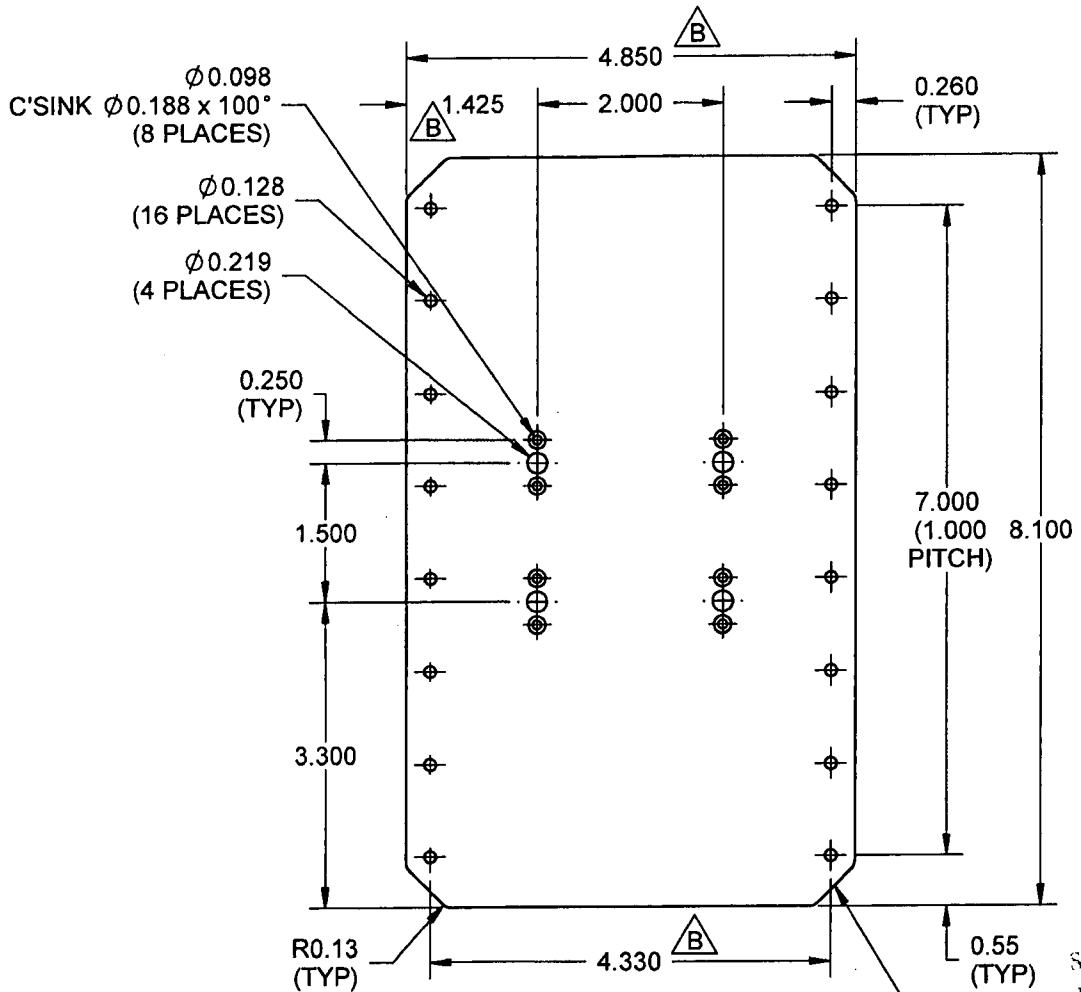
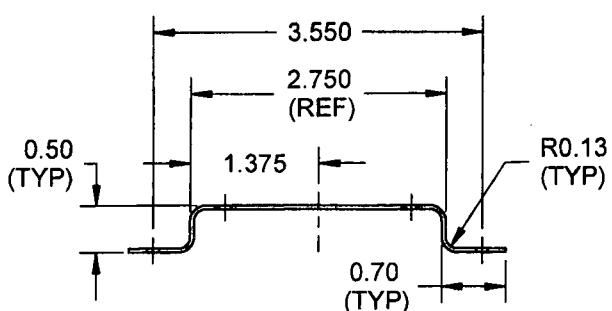
WORK ORDER
NO. *29944*

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DESIGN <i>RF</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>RF</i>	DRAWING NO. D3303	REV. B	SHEET 4 OF 4
DATE 06.08.17	TITLE HEAD REST	SCALE 1:2		

**△ D3303-3F BRACKET FLAT PATTERN****D3303-3 BRACKET BEND DETAIL****NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK SHEET (REF. DART SPEC. M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005.4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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